

Work Order ID 71782

Tuesday, July 12, 2011 8:55:33 AM

Page 1

Item ID: D3463-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Weldment Assembly

Start Date: 7/12/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *11-07-12*

Tooling:

Date:

Run Start

QC:

Date:


SPC (Y/N):


Date:


Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------


Draw Nbr	Revision Nbr
D3463	Rev B

100		0.00
	Large Fab	
Large Fab	Memo	0.00
Large Fab	Weld assembly as per dwg D3463 using DT8875	

EL 11-7-12 

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
		
QC	Memo	0.00
Quality Control		

Pl 11-07-13

120	QC5- Inspect part completeness to step on W/O	0.00
		
QC	Memo	0.00
Quality Control		

S 11-07-13
LM

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Item ID: D3463-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 7/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

117745

Memo

0.00

Powder Coating

1- Mask areas indicated on dwg D3463 (holes, threads)

START TIME: 7:30

OVEN TEMPERATURE: 1700

FINISH TIME: 8:20

2 BK 11-7-15.

140



HandFinish

Wing Walk as per dwg QSI005 4.4 Batch 1117867

0.00

Memo

Hand Finishing

2 4 11-7-15

150



QC

QC3- Inspect Part Finish

0.00

Memo

Quality Control

0.00

87 11-07-15 (x2)

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Item ID: D3463-042**Accept****Setup Start****Revision ID:****Stop****Item Name:** Step Weldment Assembly**Start Date:** 7/12/2011 **Start Qty:** 2.00**Cust Item ID:****Required Date:** 7/15/2011 **Req'd Qty:** 2.00**Customer:****Reference:****Run Start****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Stop****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

Identify as per dwg & Stock Location: *474*

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*4/7/15 (2)**11/7/19**MF**11-07-19*

Picklist Print

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Work Order ID: 71782

Parent Item: D3463-042

Parent Item Name: Step Weldment Assembly





Start Date: 7/12/2011

Required Date: 7/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV. A 05.11.18 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806  SS DOWEL PIN 1" LONG		Purchased	No			100	Each	80.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		80							
				117606		80							
D3453-3  Clevis		Manufactured	No			100	Each	6.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
				70854		6							
D3453-5  Plug		Manufactured	No			100	Each	9.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA023		9							
				59204		9							
D3463-1  Arm		Manufactured	No			100	Each	2.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				69948		2							

EL 11-7-12

4

EL 11-7-12

2

EL 11-7-12

2

EL 11-7-12

2

Picklist Print

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Work Order ID: 71782



Parent Item: D3463-042



Parent Item Name: Step Weldment Assembly

Start Date: 7/12/2011

Required Date: 7/15/2011

Start Qty: 2.00

Required Qty: 2.00

D3463-3

Manufactured No

100

Each

20.0000

1

2



Step



EL 11-7-12

Location

Loc Qty

Loc Code

WA025

20

46269

20

8

D3463-5

Manufactured No

100

Each

37.0000

2

4



End Cap



EL 11-7-12

Location

Loc Qty

Loc Code

WA

36

70819

36

3

WA004

1

58928

1

1

D3463-7

Manufactured No

100

Each

10.0000

1

2



Drag Arm



EL 11-7-12

Location

Loc Qty

Loc Code

WA025

10

70857

10

8

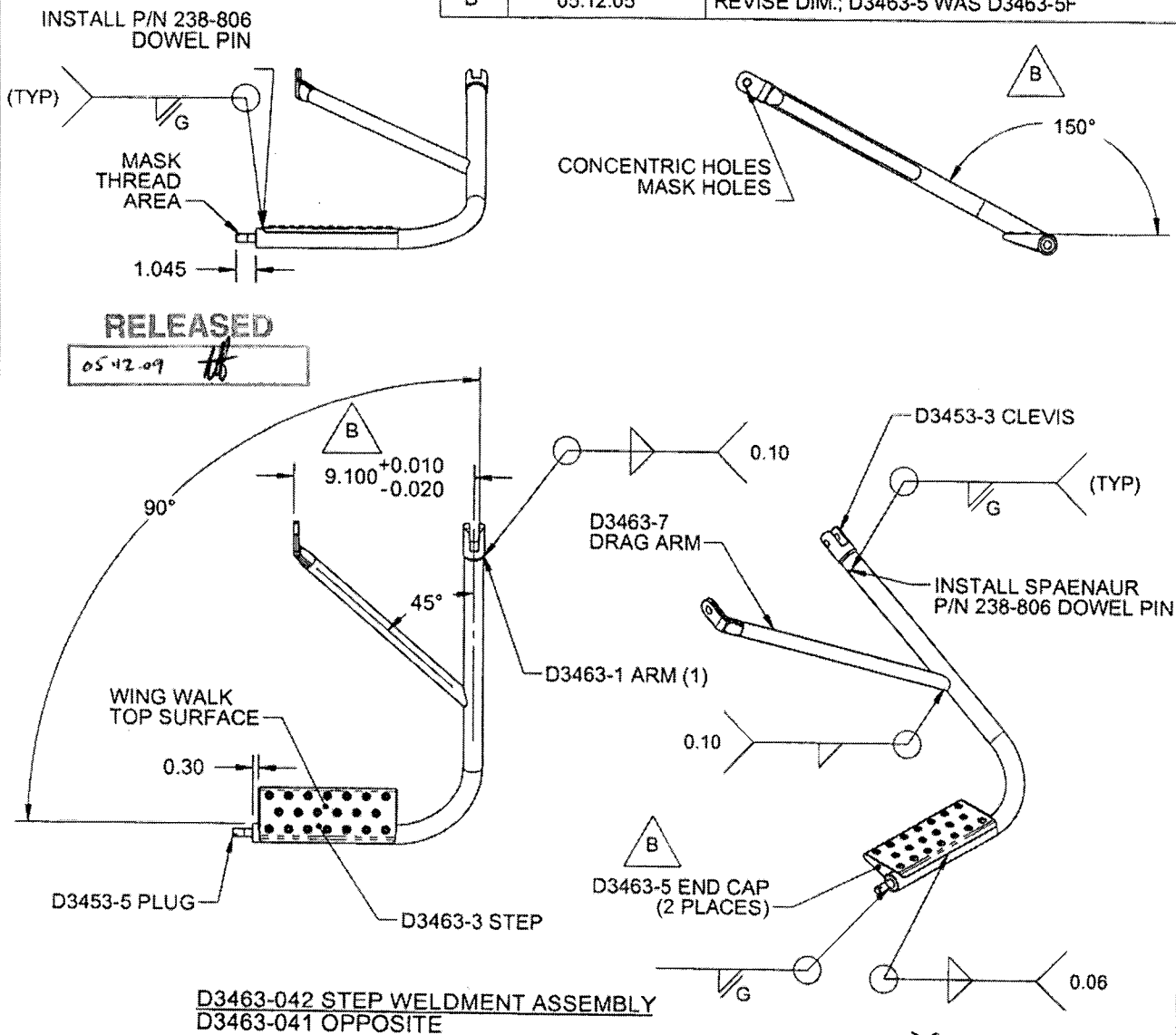
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Shop Packet Print

Page 2



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



NOTES:

- 1) WELD PER DART QSI 004
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
 - 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- # 71782

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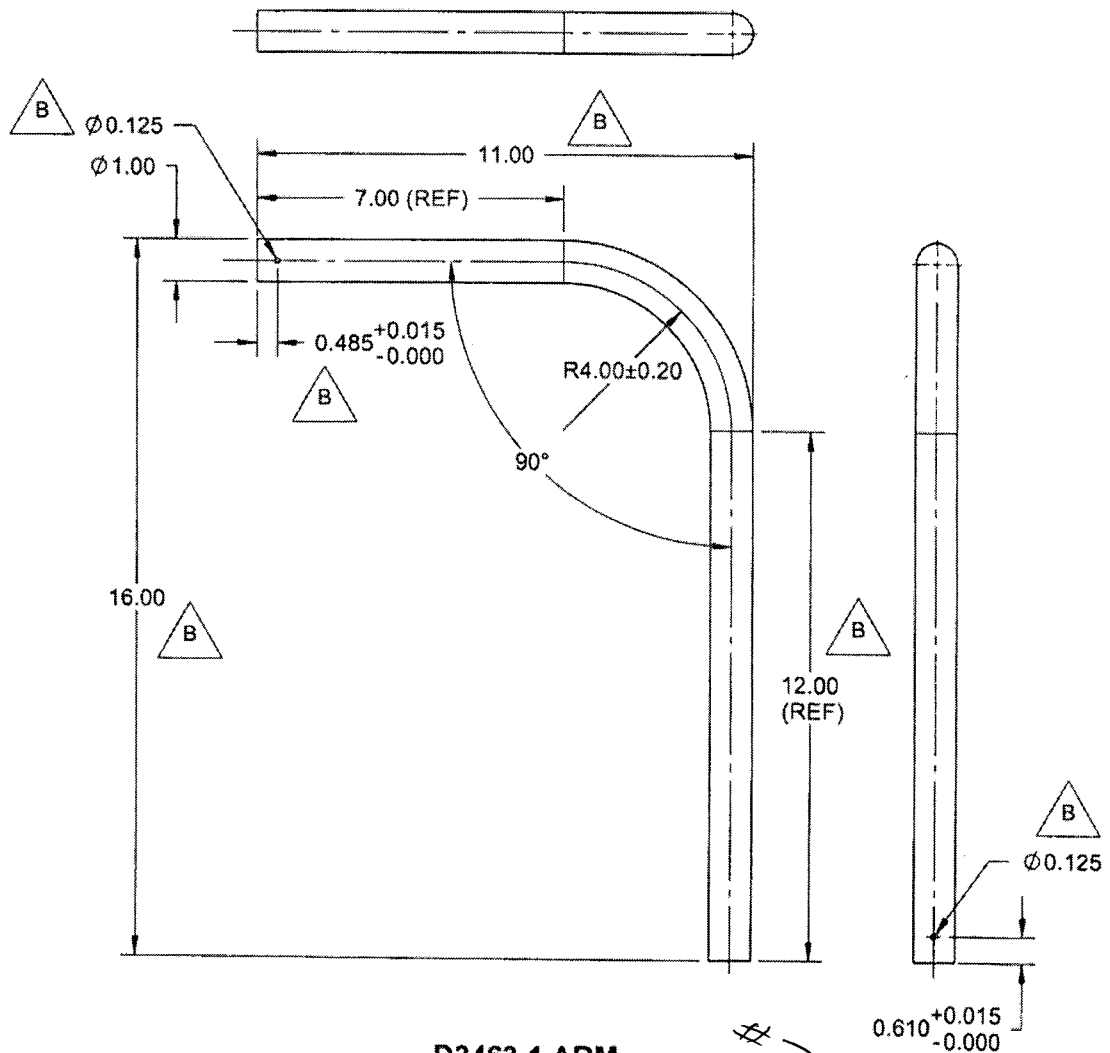
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.09 *[Signature]*



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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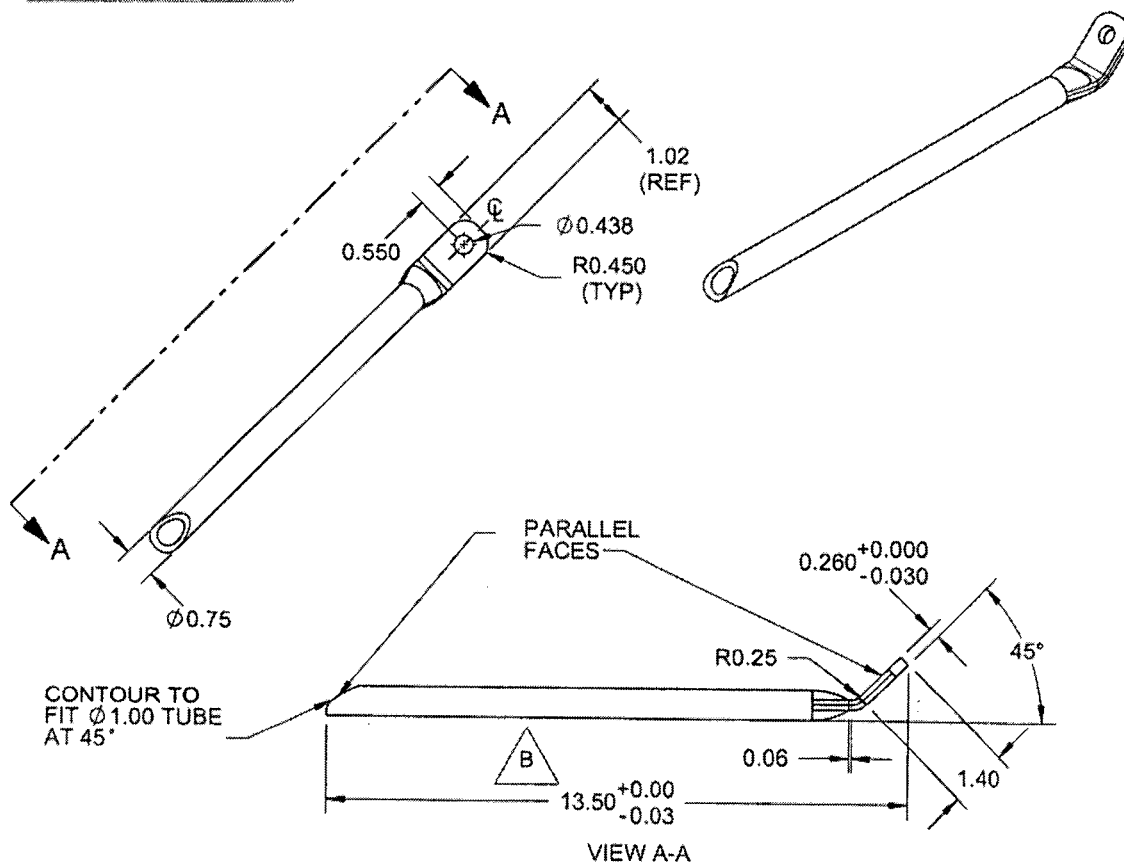
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CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.09 #



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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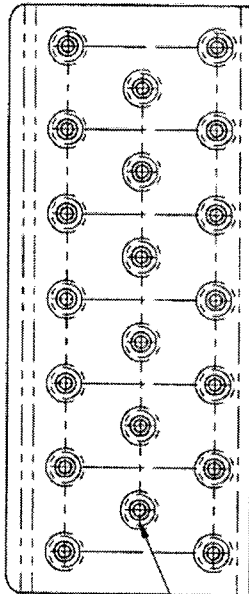
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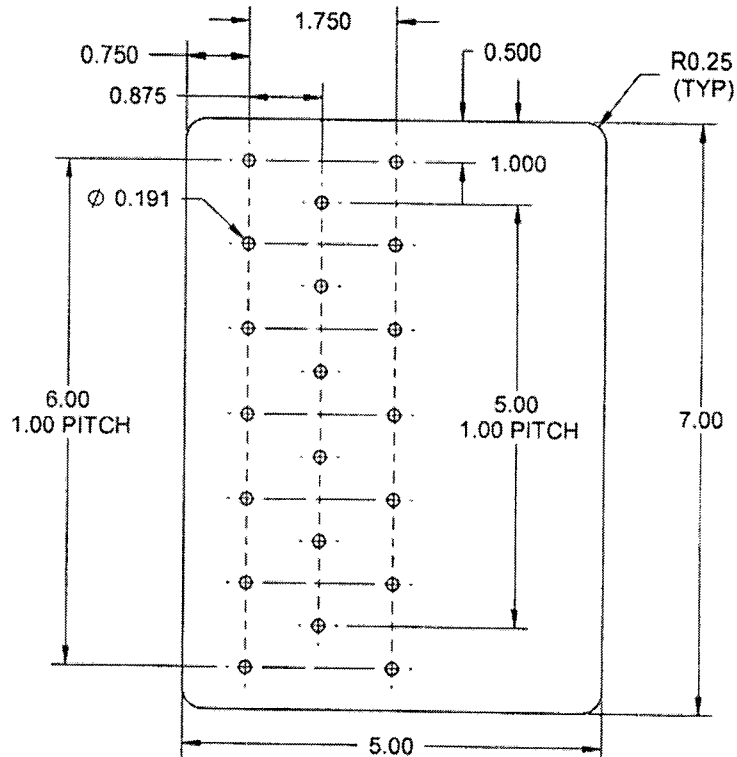
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DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:2

RELEASED

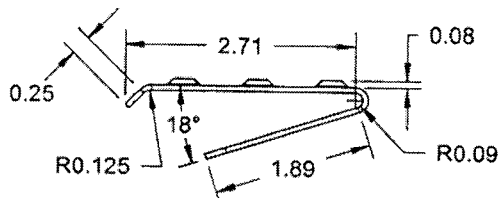
05.12.05 #



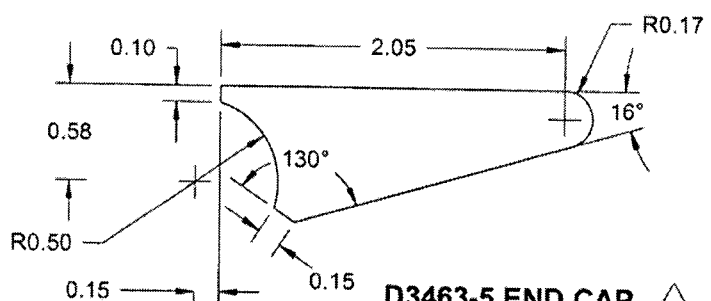
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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